



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
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D4131-043
Job Sheet 181698



Part No: D4131-043

Job Qty: 4 ea

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/4/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,9 IPP Rev:A 10.10.06 new issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		9/7/18	0.00	0.00	Start Up Waterjet		<i>SC 8/15/09</i>
100	Waterjet	4 pcs		9/7/18	0.00	0.45	Waterjet1		<i>SC 8/15/09</i>
120	QC	4 pcs		9/7/18	0.00	0.00	QC8		<i>18-08-10</i>
130	Small Fab	4 pcs		9/7/18	0.00	0.25	Small Fab-6		<i>DAS 38</i>
150	QC	4 pcs		9/7/18	0.00	0.00	QC5		<i>DD 18-08-15</i>
160	HandFinish	4 pcs		9/7/18	0.00	0.23	HandFinish1		<i>DD 18-08-15</i>
161	QC	4 pcs		9/7/18	0.00	0.00	QC7-3		<i>DAS</i>
165	Small Fab	4 pcs		9/7/18	0.00	0.25	Small Fab-6		<i>DAS</i>
166	QC	4 pcs		9/7/18	0.00	0.00	QC5		<i>AUG 24 2018 38</i>
180	Packaging	4 pcs		9/7/18	0.00	0.00	Packaging3-2		<i>AUG 24 2018 38</i>
190	QC21-SA	4 Ea		9/7/18	0.00	0.00	QC21		<i>DAS</i>

Part Op 100 - 1-Cut D4131-7 as per Dwg Dwg Rev: 7C Prog Rev: 7C 2-Deburr as required
Descriptions: 130 - COUNTER SINK AS PER DWG Deburr if necessary.
165 - ASSEMBLE NUT PLATES AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.7228 sf (.1807 ea)	90-Start up Operation	
MS20426AD3-3	Rivet	32 Ea (8 ea)	165-Small Fab	
MS21069L3	Anchor Nut	16 Ea (4 ea)	165-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	1	139	0
165-Small Fab	MS20426AD3-3	32	3,869	0
	MS21069L3	16	162	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	<i>9/01</i>	Diameter
2	Doubler Assembly	0.191Inches	0.196	<i>0,196</i>	Diameter

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Hold-as-is ☐ Suspected ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		DART AEROSPACE Container No: S100777 Part: D4131 - 043 Job No: 181698 Serial No/Batch: S100777 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 08/09/18					
Description Work Order Deviation									
Root Cause <table style="width: 100%;"> <tr> <td style="width: 50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width: 50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width: 100%;"> <tr> <td style="width: 50%;"> Pressure/Fo ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width: 50%;"> BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> </table>				Pressure/Fo ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐
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			+ 0.005	0.190	
			- 0.001		
3	Doubler Assembly	0.250Inches ± 0.010	0.260 0.240	0,252	
4	Doubler Assembly	0.500Inches ± 0.010	0.510 0.490	0,503	
5	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0,407	
6	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395	0,406	
7	Doubler Assembly	0.590Inches ± 0.030	0.620 0.560	0,595	
8	Doubler Assembly	0.660Inches ± 0.030	0.690 0.630	0,666	
9	Doubler Assembly	3.640Inches ± 0.030	3.670 3.610	3,645	
10	Doubler Assembly	4.000Inches ± 0.010	4.010 3.990	4,004	
11	Doubler Assembly	4.100Inches ± 0.030	4.130 4.070	4,103	
12	Doubler Assembly	4.810Inches ± 0.030	4.840 4.780	4,812	
13	Doubler Assembly	4.600Inches ± 0.010	4.610 4.590	4,605	
14	Doubler Assembly	5.410Inches ± 0.030	5.440 5.380	5,414	
15	Doubler Assembly	0.063Inches ± 0.010	0.073 0.053	0,063	

Plex 8/7/18 7:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause	FAULT CATEGORY																																																																	
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